

Work Order ID 73185

Friday, August 26, 2011 7:14:44 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3912 | B |

| | | | | | | | | | |
|-----|----------|------|--|--|--|--|--|--|--|
| 100 | Pick Kit | 0.00 | | | | | | | |
|-----|----------|------|--|--|--|--|--|--|--|



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| Packaging | Memo | 0.00 | | | | | | | |
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Packaging

EP 11/08/30 (2)

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
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| Small Fab | Memo | 0.00 | | | | | | | |
|-----------|------|------|--|--|--|--|--|--|--|

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

EP 11/08/30 (2)

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|



| | | | | | | | | | |
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| QC | Memo | 0.00 | | | | | | | |
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Quality Control

Subal/31

(2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 73185

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|----------------|---------------------------|------------|------|-------|---------------|--|
| Item ID: | D3912-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Eyebolt Receiver Assembly | | | | | |
| Start Date: | 8/26/2011 | Start Qty: | 2.00 | | Cust Item ID: | |
| Required Date: | 9/9/2011 | Req'd Qty: | 2.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 Packaging Packaging | Identify as per dwg & Stock Location: Memo | 0.00 0.00 | | | | | | 11-08-31 | |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 11/8/31 | 11-08-31 |

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NOTE: Date & initial all entries

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Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
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 3. **Methodology**
 4. **Results**
 5. **Conclusion**
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2
5/11/08/30

Loc Code

32

200



11/11/11

1
2
|| ES 11/08/30

Loc Code

22

20

2



2 4 5/11/08/30

Loc Code

4

4

25

25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:14:41 AM

Page 2

Work Order ID: 73185

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

D3912-5 Manufactured No

100 Each

8.0000

2

4



Eyebolt Plate



EP 11/08/30

Location

Loc Qty

Loc Code

ST091

8

72986

8

4

D3801-1 Manufactured No

Each

14.0000

2



Hand Retractable Spring Plunger



EP 11/08/30

Location

Loc Qty

Loc Code

ST083

12

69498

12

2

ST084

2

68379

2

MS20615-4M20 Purchased No

100 Each

216.0000

8

16



RIVET



EP 11/08/30

Location

Loc Qty

Loc Code

GA

216

117071

46

16

118571

170

MS21209-F615 Purchased No

Each

37.0000

2



Heli-Coil



EP 11/08/30

Location

Loc Qty

Loc Code

ST305

37

108170

23

2

108244

14

Friday, August 26, 2011 7:14:42 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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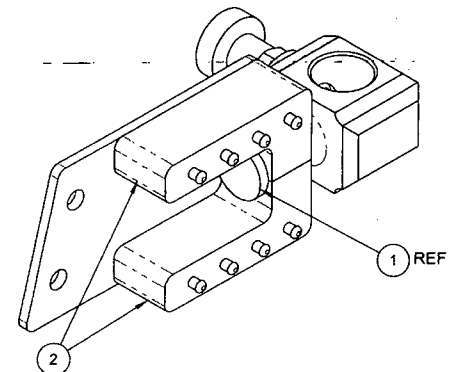
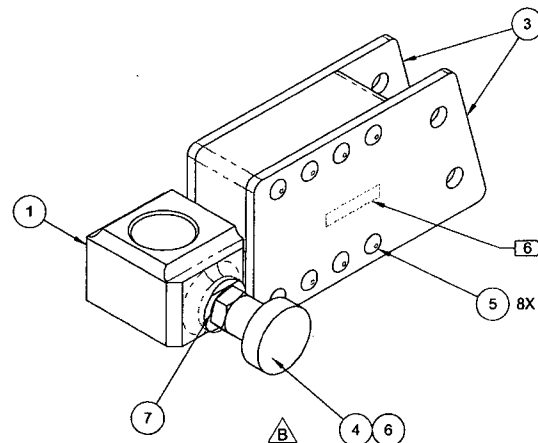
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20615-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149F0332P | WASHER |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73185
0211108126

SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

| | | | |
|------------|--|-----|----------|
| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. | JPH | 10.06.28 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 1/5 | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.06.28 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS
SHEET 1 OF 3

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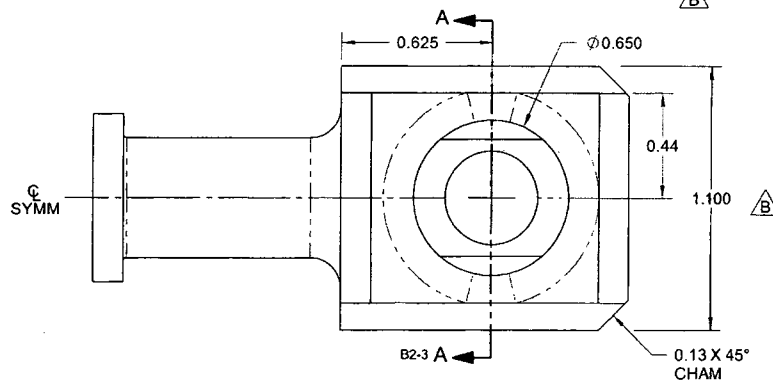
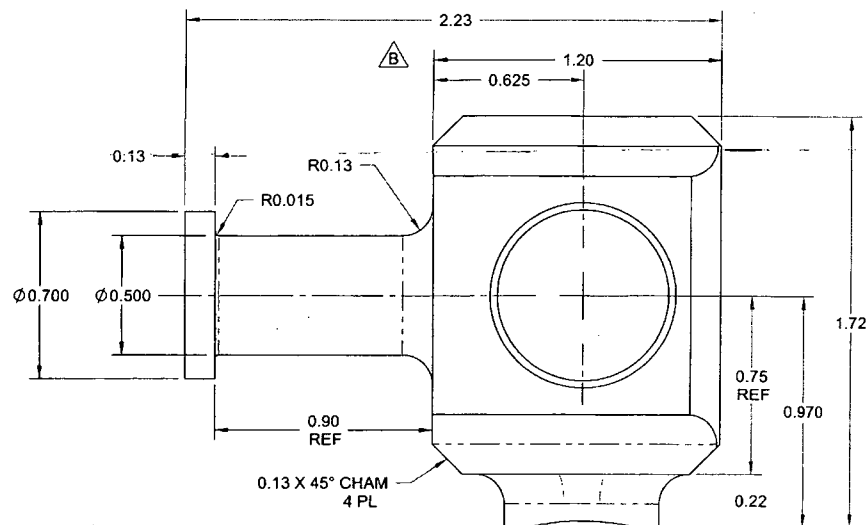
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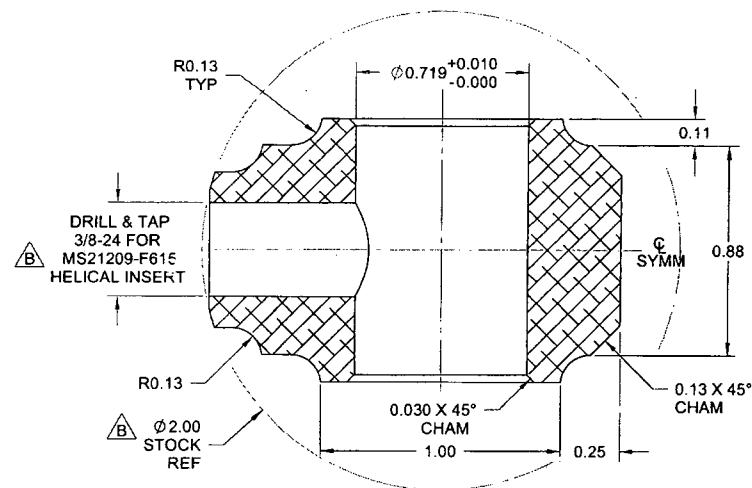
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | JP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | REV. B |
| MFG. APPR. | JP | D3912 | SHEET 2 OF 3 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | EYEBOLT RECEIVER ASSY | NTS |
| DATE | 10.06.28 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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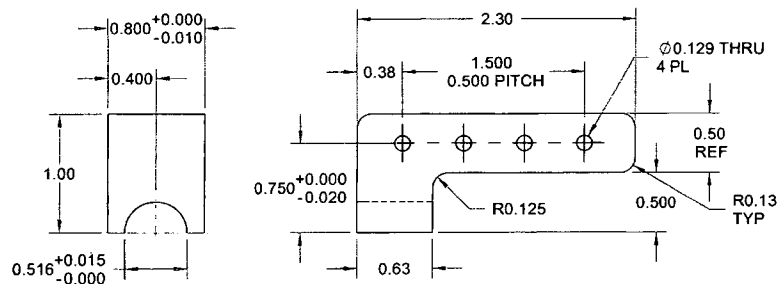
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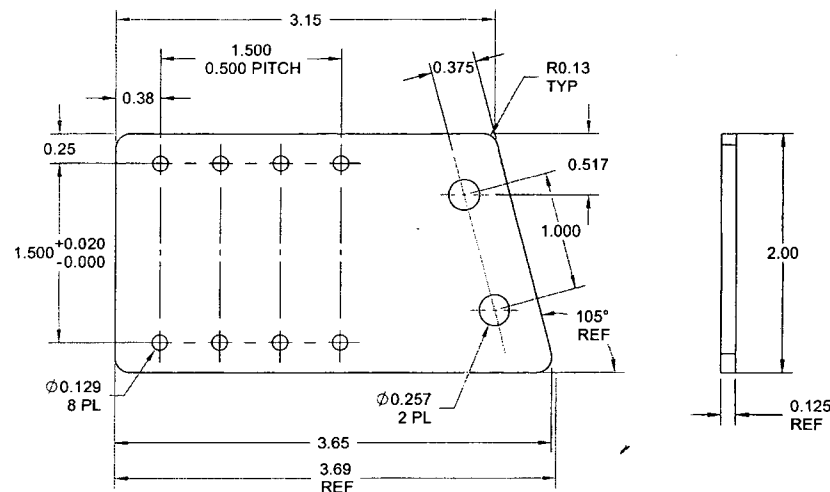
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| | | | | | | | | |

NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
mm

| | | | |
|--|----------|--|--------------|
| DESIGN | 115 | DART AEROSPACE LTD | |
| DRAWN | RT | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BA | DRAWING NO. | REV. B |
| MFG. APPR. | RT | D3912 | SHEET 3 OF 3 |
| APPROVED | RT | TITLE | SCALE |
| DE APPR. | RT | EYEBOLT RECEIVER ASSY | NTS |
| DATE | 10.06.28 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries